



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D205-634-145
Job Sheet 171293



Part No: D205-634-145

Job Qty: 1 ea

Part Name: Replacement Skidtube with Thru-Bolt Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/30/18

Job Tracking No:

Due Date: 2/28/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG D2580-049 REV H, IIN-D205-634 REV I IPP REV:B 14.04.21 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	2/27/18	2/27/18	0.00	0.00	Start Up Skid tubes-1		MGA
110	Skid tubes	1 pcs	2/27/18	2/27/18	0.00	2.01	Skid tubes-2		MGA
120	CNC Bend Skid tubes	1 pcs	2/27/18	2/27/18	0.49	0.60	CNC Bend Skid tube		MGA 1:8
130	Skid tubes	1 pcs	2/27/18	2/27/18	0.00	2.01	Skid tubes-2		MGA
140	QC	1 pcs	2/27/18	2/27/18	0.00	0.00	QC5		MGA
150	Skid tubes	1 pcs	2/27/18	2/27/18	0.00	2.01	Skid tubes-2		MGA
160	QC	1 pcs	2/27/18	2/27/18	0.00	0.00	QC10		MGA
170	QC	1 pcs	2/27/18	2/27/18	0.00	0.00	QC5		MGA
180	HandFinish	1 pcs	2/27/18	2/27/18	0.00	1.07	HandFinish2		MGA
190	Powdercoat	1 pcs	2/27/18	2/27/18	0.00	0.18	Powdercoat1		MGA
200	QC	1 pcs	2/27/18	2/27/18	0.00	0.00	QC3		MGA
210	HandFinish	1 pcs	2/28/18	2/28/18	0.00	1.07	HandFinish4		MGA
220	QC	1 pcs	2/28/18	2/28/18	0.00	0.00	QC5		MGA
225	DC	1 pcs	2/28/18	2/28/18	0.00	0.00	DC		MGA
230	Packaging	1 pcs	2/28/18	2/28/18	0.00	0.00	Packaging3-1		MGA
240	QC21-FG	1 Ea	2/28/18	2/28/18	0.00	0.00	QC21		MGA

Part Op 110 - 1- PICK D2580-1 2- SPOT DRILL 2 AFT RUN ON WEARPLATE HOLES USING DT10021, DRILL 3.630" HOLES
Descriptions: USING DT8462 (83.94" FROM AFT OF D2580-1 REF. ONLY)

120 - 1-Bend as per program D2580 SKID on CNC Bender and Folio FT 16 2-Cut tubes as per Dwg. D2580 3- Scribe batch# in aft end of tube

130 - 1-Deburr ends after cutting and remove bending marks. Prepare tube for welding D2576-3 step remove alodine as required. 2-Locating from most fwd saddle hole, drill most fwd wearplate hole using DT9793 (10.832 REF) as per dwg D2580 sheet 7. 3-Open run-on wearplate holes to finished size 0.508" at locations (5.338/ 5.985/ 10.832/ 3.63 REF) as per dwg D2580 sheet 7. 4-Drill pilot holes for aft cap using DT8215, Open to finished size.

150 - 1-Weld step D2576 as per Dwg. D2580 and QSI 004 A/R Aluminum Rod 038601 - Grind welds flush. 2-Touch up alodine on run on wearplate holes prior to swaging 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and as per dwg 4-DRILL TOWING HOLE USING DT8091 5-DEBURR

180 - Realodine tube as per QSI 005

190 - START TIME: 9:40 OVEN TEMPERATURE: 320° FINISH TIME: 10:10

210 - 1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 Sikaflex expire date: 2-Coat D2594-3 O' rings with

220 - Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

225 - Photocopy D205-634 bluefile & type labels per PPP D205-634-145 CHG001

230 - Identify and pack for shipping as per PPPD205-634-145 Location : FG073

5056316 LH

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2580-1	205 Bent Tube	1 Ea (1 ea)	90-Start up Operation	S053988
AN3-5A	Bolt	2 Ea (2 ea)	210-HandFinish	S041106
AN4-45A	Bolt	8 Ea (8 ea)	210-HandFinish	S017093
D2570	Bushing	16 Ea (16 ea)	210-HandFinish	S050169
D2576-3	Step (Machining Detail)	1 Ea (1 ea)	210-HandFinish	S156023
D2594-1	Plug	8 Ea (8 ea)	210-HandFinish	S054786
D2594-3	O-Ring	8 Ea (8 ea)	210-HandFinish	S049975
D2855	Cap	1 Ea (1 ea)	210-HandFinish	F147805
D4202-1	Spacer	24 Ea (24 ea)	210-HandFinish	S039216
D5061-1	Fwd Wearplate	1 Ea (1 ea)	210-HandFinish	F165526
D5061-3	Aft Wearplate	1 Ea (1 ea)	210-HandFinish	S023925
MS21042-4	Nut	8 Ea (8 ea)	210-HandFinish	S038763
NAS1149D0332J	Washer	2 Ea (2 ea)	210-HandFinish	S020606

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2580-1	1	5	0
210-HandFinish	AN3-5A	2	263	0
	AN4-45A	8	110	0
	D2570	16	388	0
	D2576-3	1	45	0
	D2594-1	8	428	0
	D2594-3	8	581	0
	D2855	1	74	0
	D4202-1	24	959	0
	D5061-1	1	3	0
	D5061-3	1	3	0
	MS21042-4	8	203	0
	NAS1149D0332J	2	4,012	0

Part Specifications	
Specifications could not be found.	

Plex 2/7/18 8:53 AM Dart.Gagnon.Michelle

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Container No: S056316



Part: D205-634-145

Job No: 171293

Serial No/Batch: S056316

Revision:

Inspector:

Date: 03/29/18

ITEM	QTY -041	QTY -045	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
1	X				D2580-041	SKIDTUBE ASSEMBLY
2		X			D2580-045	SKIDTUBE ASSEMBLY
3			X		D2580-047	SKIDTUBE ASSEMBLY
4				X	D2580-049	SKIDTUBE ASSEMBLY
20	1	1	1	1	D2500-1-190	EXTRUSION
21			16	16	D2570	BUSHING
22	1	1	1	1	D2575-3	STEP
23		4			D2579	SPACER
24	16	16	8	8	D2594-1	PLUG
25	16	16	8	8	D2594-3	O-RING
26	1	1	1	1	D2596	205 WEB
27	1	1	1	1	D2555	AFT CAP
28	1	1			D3554-5	WEARSHOE
29	1	1			D3554-9	WEARSHOE
30	1	1			D3554-11	WEARSHOE
31	1	1			D3554-13	WEARSHOE
32	20	20	24	24	D4202-1	SPACER
33			1		D4406-041	WEARPLATE ASSEMBLY
34			1		D4406-043	WEARPLATE ASSEMBLY
35				1	D5051-1	FWD WEARPLATE
36				1	D5051-3	AFT WEARPLATE
50	50	50			AL57-1032-130 or AK57-1032-130 or AK54-1032-130 or AELS-1032-130	INSERT
51	50	50			AN5C4A	BOLT
52	2	2	2	2	AN5-5A	BOLT
53			8	8	AN4-45A	BOLT
54	50	50			NAS1149C0332R	WASHER (AN550C10L)
55	2	2	2	2	NAS1149D0332J	WASHER (AN550JD10L)
56			8	8	MS21042-4	NUT (OR MS21042L4)

GENERAL NOTES:

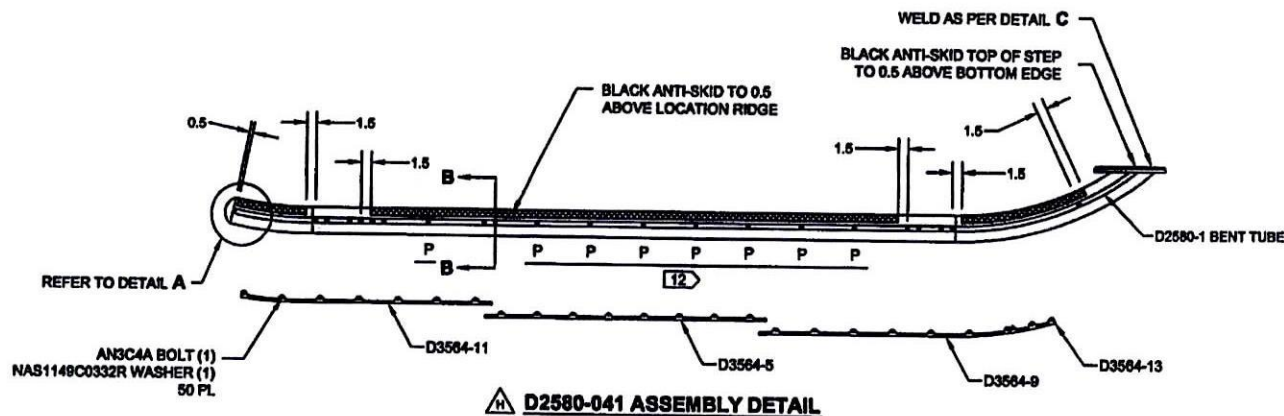
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT (-041/-047/-049) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
POWDER COAT (-045) GREEN SANDTEX (REF 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- 3) TOLERANCES ARE PER DART QSI 015 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2580-041 = 33.7 lbs
D2580-045 = 33.7 lbs
D2580-047 = 45.1 lbs
D2580-049 = 32.0 lbs
- 8) WELDING PER DART QSI 004.
- 9) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DT8217 & DT8937 ONLY FOR D2580-041/-045 TO LOCATE AND DRILL 20.297 HOLES FOR WEARSHOE INSERTS. INSTALL AL57-1032-130 PER SECTIONS B-B AND F-F (50 PLACES) AFTER FINISH. INSTALL AN5C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241-291.
- 12) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/-045 AND 8 PLACES FOR D2580-047/-049)
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2555 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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WITHOUT NOTICE
WORK ORDER
NO. 171293-4 mcf
FEB 08 2018

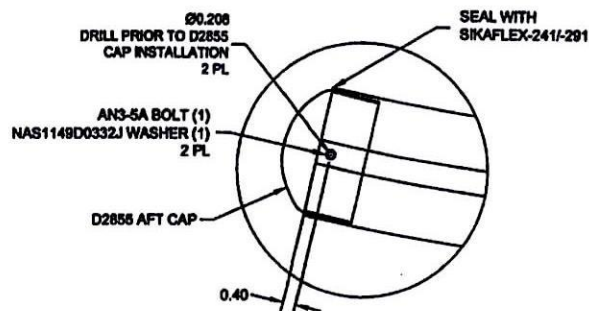
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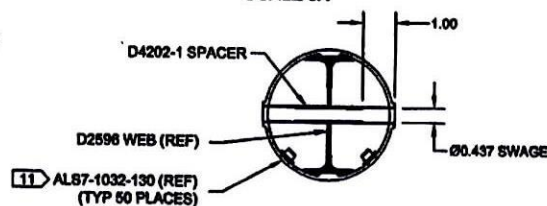
H	SHEET: PL DELETE D3556-1/-5/-13 GASKETS, WEIGHTS UPDATED ACCORDINGLY. SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS	SAD	17.06.09
G	ADDED -045, -047 WEIGHT UPDATED PER DSI 9508	AJS	14.04.09
F	INCORPORATE DEO D2580-E-1 PER PART12-218	DC	13.06.20
E	ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN B3-5); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8937 WAS T02577-205 (ZN C4-1)	RF	11.06.21
D	CHANGE TO 55 WEARPLATES AND GASKETS, INCLUDE DEO 5124/ 5153	PH	07.04.05
C	REDRAWN, INCLUDED DEO 9084/ 9097	CP	06.06.26
B	AS MANUFACTURED	DS	06.12.02
A	NEW ISSUE	DS	06.06.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	SAD		
CHECKED	7/10/09		
MFG. APPR.	13/10/09		
APPROVED	13/10/09		
DE APPR.	13/10/09		
DATE	17.06.09		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2580 REV. H SHEET 1 OF 9 TITLE 205 SKIDTUBE ASSEMBLY SCALE NTS COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PREPARED AND OWNED BY DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



DETAIL A
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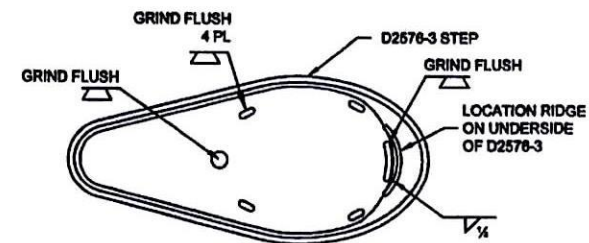


SECTION B-B
SCALE 5X



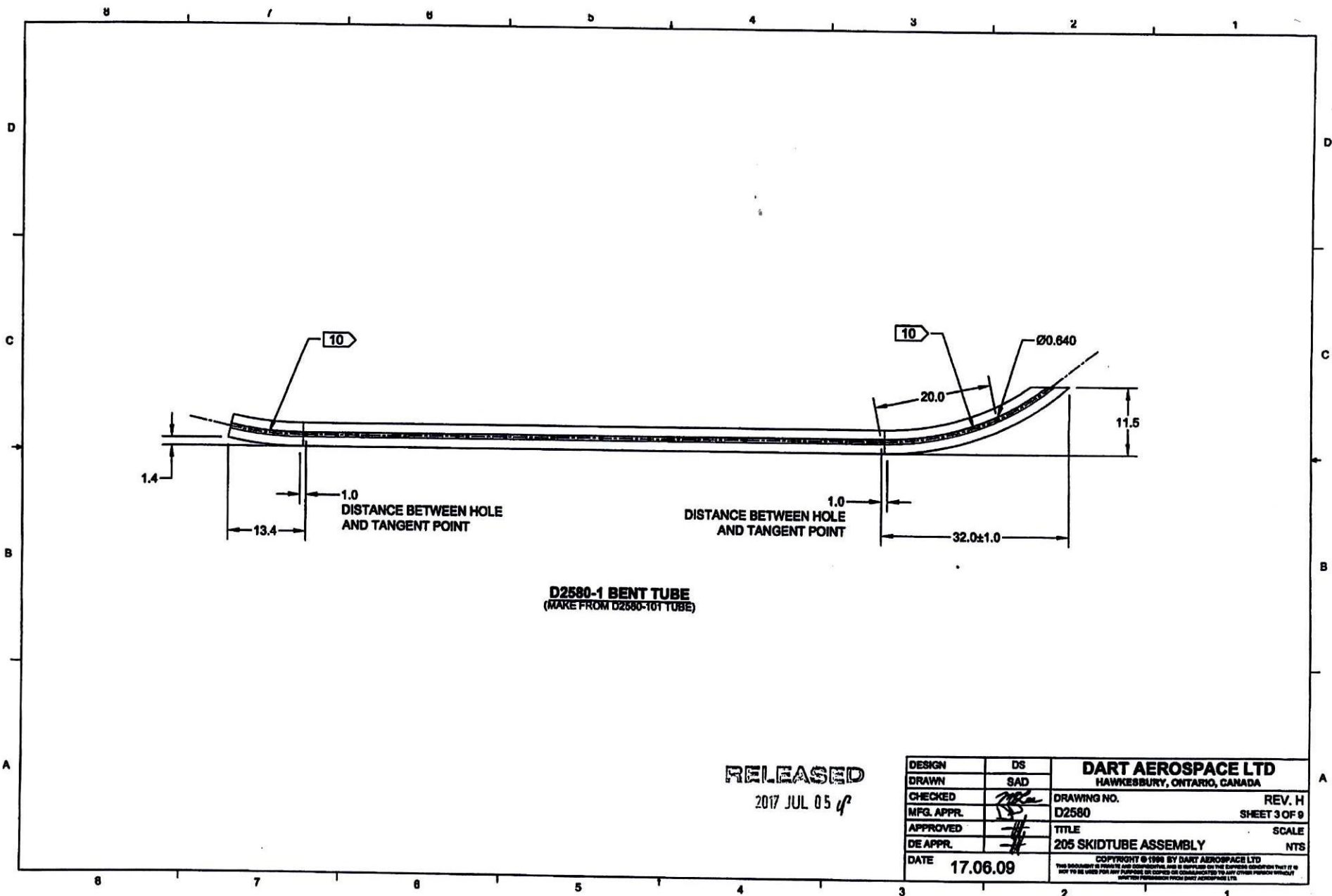
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

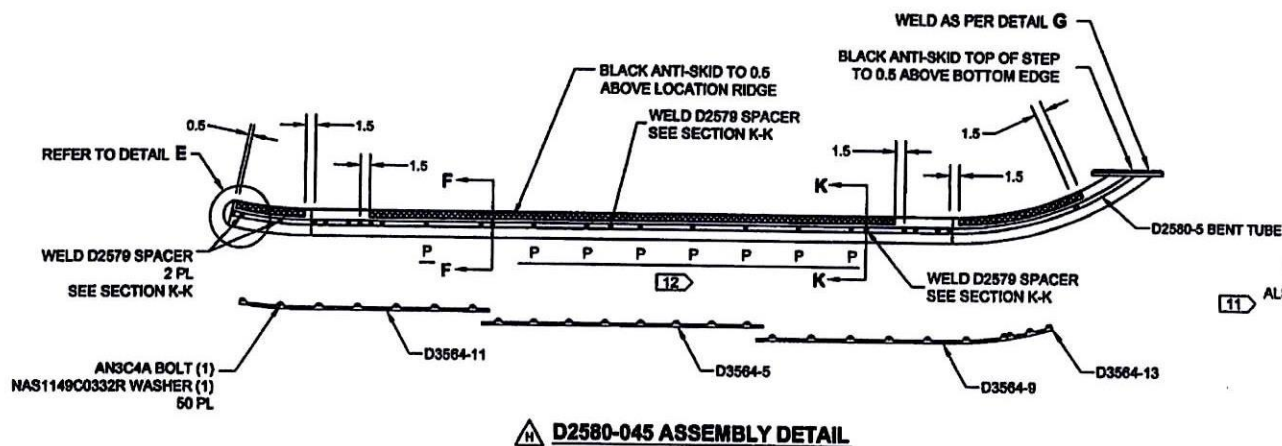
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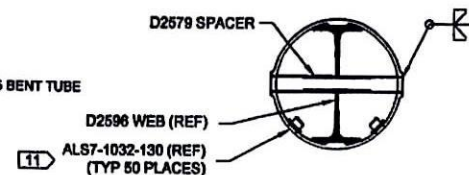
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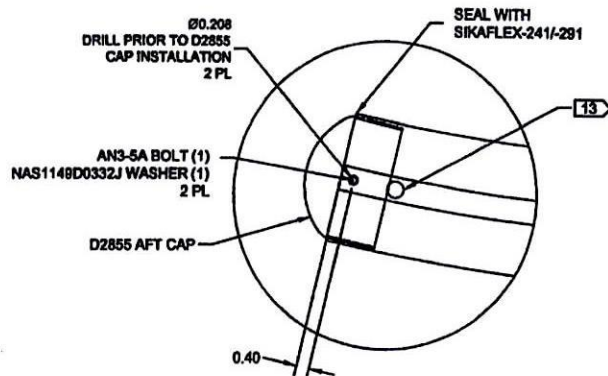
D2580-045 ASSEMBLY DETAIL

**SECTION K-K
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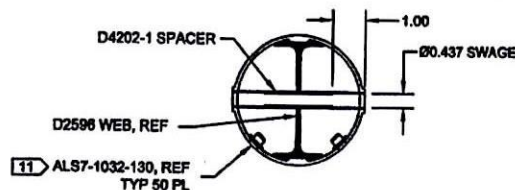
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (4 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. DO NOT C'BORE

**DETAIL E
SCALE 5X**



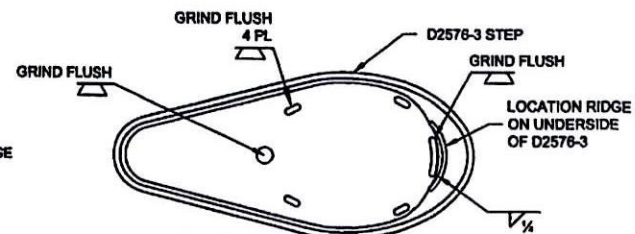
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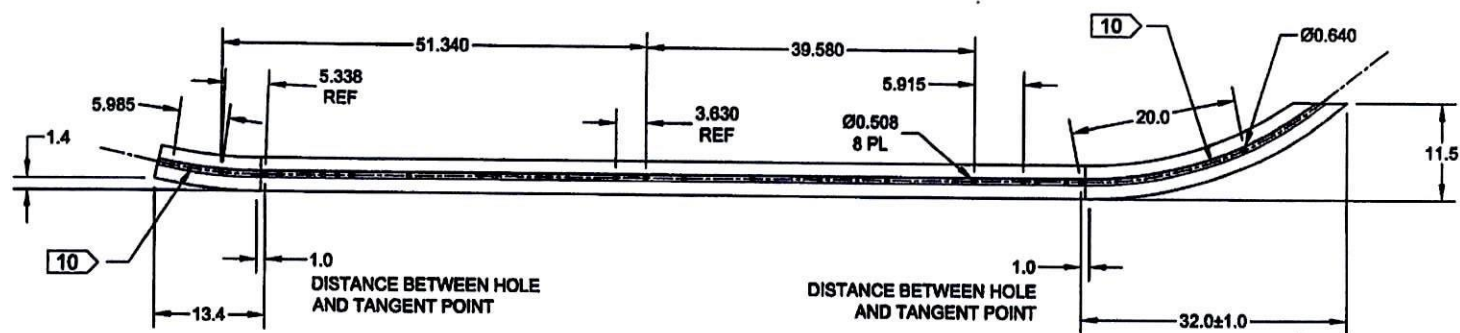


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

**DETAIL G
SCALE 5X**



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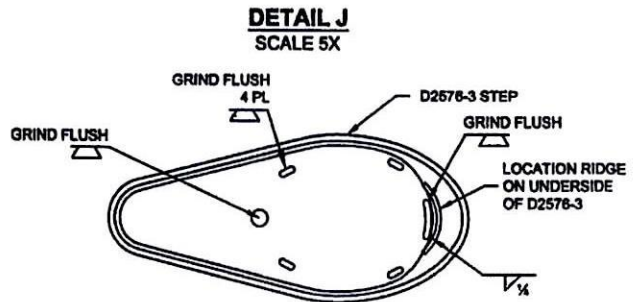
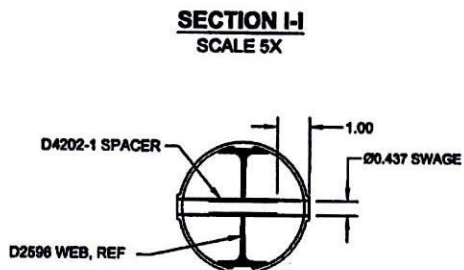
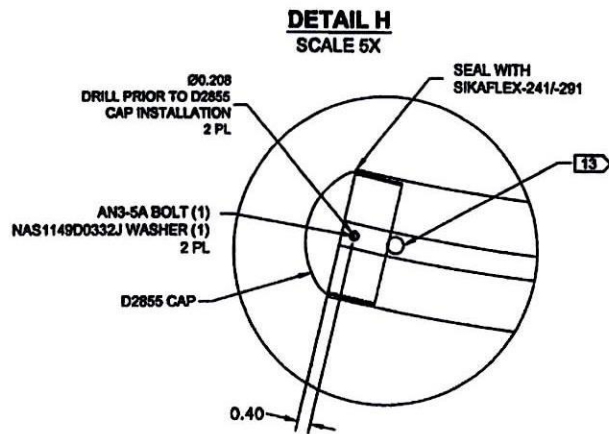
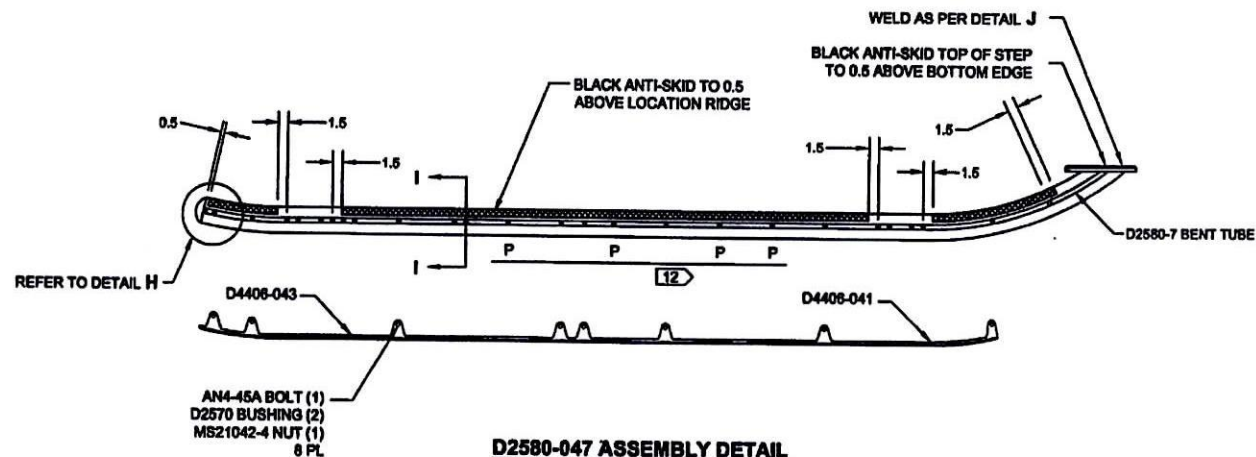


D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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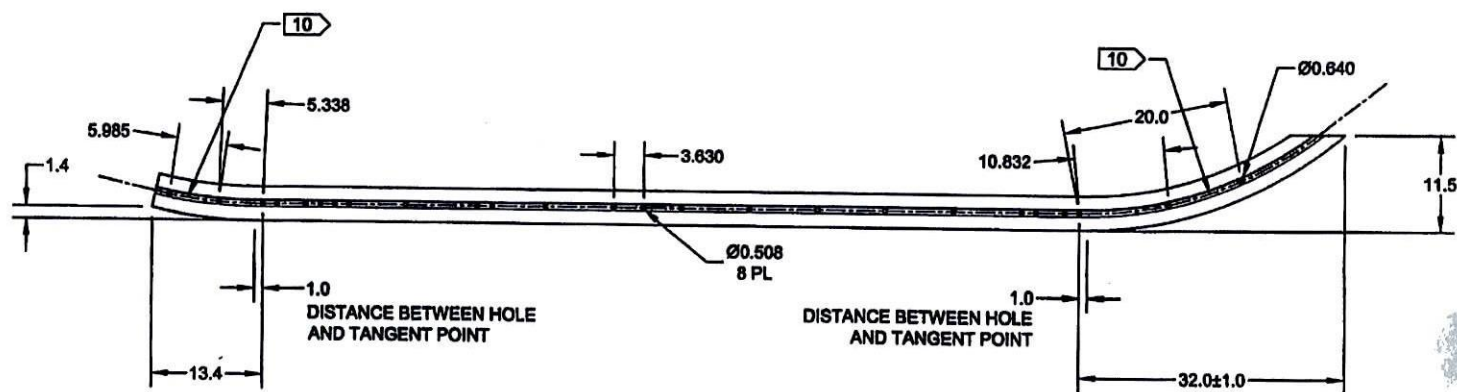
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AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

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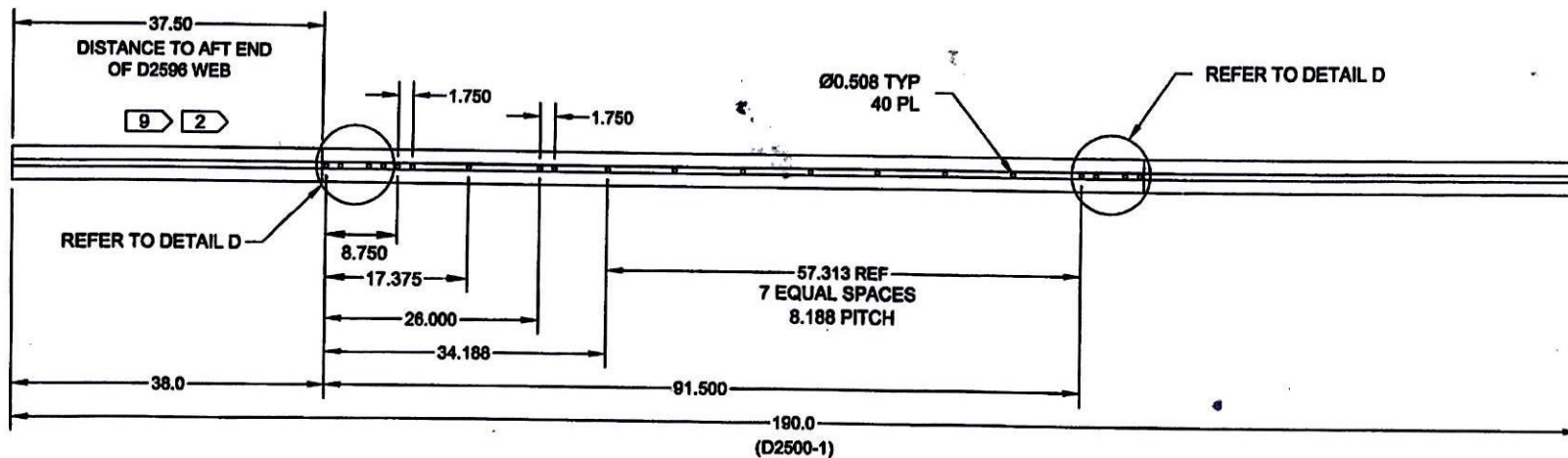


D2580-7 BENT TUBE
(MAKE FROM D2580-101 TUBE)

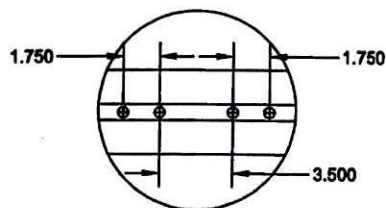
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D2580-101 TUBE



DETAIL D
SCALE 5X

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APPROVED	<i>[Signature]</i>	TITLE	SCALE
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8 7 6 5 4 3 2 1

Change Record

PAGE 1 OF 1

Part Number: D205-634-145

Description: REPLACEMENT SKIDTUBE w/ THRU BOLT WEARPLATES[illegible]